



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

May 15
D350-567-115
Job Sheet 176197



Part No: D350-567-115

Job Qty: 4 ea

Part Name: Replacement Interior Window



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/18/18

Job Tracking No:

Due Date: 5/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG DSI9745-011 REV A, IIN-D350-567 REV E SHEET 28 IPP Rev:A New Issue 04-08-24 JLM IPP Rev:B
CHG#2 ECN 1055 07-11-21 DD verified by:EC IPP Rev:C 08-10-07 as per revD DD verified by: IPP REV:D
13.10.15 AS PER IIN REV.E DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		5/15/18	0.00	0.00	Start Up Stores/Pkg-2		MAY 10 2018 <i>6</i>
110	Packaging	4 pcs		5/15/18	0.00	0.00	Packaging1-3		MAY 10 2018 <i>6</i>
120	QC	4 pcs		5/15/18	0.00	0.00	QC4		<i>6</i>
125	DC	4 pcs		5/15/18	0.00	0.00	DC		<i>6</i>
130	Packaging	4 pcs		5/15/18	0.00	0.00	Packaging3-12		<i>6</i>
140	QC21-FG	4 Ea		5/15/18	0.00	0.00	QC21		<i>6</i>

Part Op 125 - Photocopy bluefile and create labels per PPP D350-567-115 CHG005
Descriptions: 130 - Identify and pack for shipping as per PPP D350-567-115 Location:FG032

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-4A	Bolt	16 Ea (4 ea)	90-Start up Operation	<i>5019388</i>
AN526C632R12	Screw	36 Ea (9 ea)	90-Start up Operation	<i>5024841</i>
D2463-053	1/2" Seal (\$ Per Foot)	17.6400 ft (4.41 ea)	90-Start up Operation	<i>5021111</i>
D3293-1	Doubler For Interior Window For -111	4 Ea (1 ea)	90-Start up Operation	<i>5040762</i>
D3294-1	Bracket For Interior Window For -115	4 Ea (1 ea)	90-Start up Operation	<i>5040762</i>
D3295-041	Replacement Interior Window For -111	4 Ea (1 ea)	90-Start up Operation	<i>5061060x2</i>
D3296-041	Replacement Interior Door For -111	4 Ea (1 ea)	90-Start up Operation	<i>5060700</i>
D5420-1	Doubler Plate	4 Ea (1 ea)	90-Start up Operation	<i>5049933</i>
DT8439	Template	4 (1 ea)	90-Start up Operation	<i>5049933</i>
MS20426AD3-5	Rivet	32 Ea (8 ea)	90-Start up Operation	<i>504833</i>
MS20470AD4-5	Rivet, Universal Head	8 Ea (2 ea)	90-Start up Operation	<i>5018336</i>
MS20470AD4-6	Rivet, Universal Head	460 Ea (115 ea)	90-Start up Operation	<i>5041165</i>
MS20470AD4-7	Rivet, Universal Head	60 Ea (15 ea)	90-Start up Operation	<i>5041165</i>
MS21042L06	Nut	36 Ea (9 ea)	90-Start up Operation	<i>5049859</i>
MS21062L3	Nut Plate	16 Ea (4 ea)	90-Start up Operation	<i>5057538</i>
NAS1149DN632J	Washer	36 pcs (9 ea)	90-Start up Operation	<i>5024482</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-4A	16	496	0
	AN526C632R12	36	187	0

WORK ORDER NON-CONFORMANCE / UPDATE



QA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐								
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval					
Description Work Order Deviation				Disposition								
				Completed By _____								
				nd / Supervisor ral Verification								
				A Coordinator pproval								
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐					Date: 05/10/18 Po ☐ Fol ☐ Gra ☐ We ☐ Wr ☐ Ou ☐ Off ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Container No: S070156 Part: D350-567-115 Job No: 176197 Serial No/Batch: S070156 Revision: _____ Inspector: _____ DART Aerospace Ltd. 1220 Aberdeen Street Haverhill, ON K6A 1K7 CANADA TEL: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com	
				ned Wrong Dimensions nder tolerance orrect t/Missing ved g Finish Misread Turning Sequence								
				OTHER : _____								

D2463	18	442	0
D3293-1	4	7	0
D3294-1	4	7	0
D3295-041	4	14	0
D3296-041	4	6	0
D5420-1	4	19	0
DT8439	4	0	0
MS20426AD3-5	32	8,346	0
MS20470AD4-5	8	3,334	0
MS20470AD4-6	460	4,234	0
MS20470AD4-7	60	2,608	0
MS21042L06	36	363	0
MS21062L3	16	37	0
NAS1149DN632J	36	386	0

Part Specifications

Specifications could not be found.

Plex 4/18/18 1:15 PM Dart.lajeunesse.marie

QA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																										
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Tel (613) 632-5200

Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002906	S066764	AN3-4A	Bolt	s019388	ST350	16
002906	S066754	AN526C632R12	Screw	S024841	ST327	36
002906	S066800	D2463	1/2" Seal (\$ Per Foot)	s021111	ST409	17.64
002906	S066751	D3293-1	Doubler For Interior Window For -111	s040768	ST435	4
002906	S066750	D3294-1	Bracket For Interior Window For -115	s040762	ST435	4
002906	S061060	D3295-041	Replacement Interior Window For -111	S061059	ST436	2
002906	S070155	D3295-041	Replacement Interior Window For -111	s052447	ST436	2
002906	S067650	D3296-041	Replacement Interior Door For -111	S060706	ST436	4
002906	S066749	D5420-1	Doubler Plate	s049955	ST162	4
002906	S066746	MS20426AD3-5	Rivet	F4533	GA007	32
002906	S066706	MS20470AD4-5	Rivet, Universal Head	S018536	ST311	8
002906	S066698	MS20470AD4-6	Rivet, Universal Head	S041165	ST310	460
002906	S066692	MS20470AD4-7	Rivet, Universal Head	FM134376-1	ST310	60
002906	S066691	MS21042L06	Nut	S049834	ST303	36
002906	S066684	MS21062L3	Nut Plate	s057538	ST300	16
002906	S066679	NAS1149DN632J	Washer	S024482	ST265	36

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 5/10/18 11:44 AM dart.quirion.sonia

REFERENCE ONLY

EDIT 5.0/25.7 PARTS LIST:

For customers with kits D350-567-013/-015/-017/-023/-025/-027/-117 @ CHG002 and earlier,
 Customers with kits D350-567-111 @ CHG006 and earlier,
 Customers with kits D350-567-115 @ CHG004 and earlier,
 Customers with kits D350-567-031/-031B/-111B/-115B @ CHG001 and earlier,
 Procure kit DSI 9745-011

Item	Qty -011	Part Number	Description
	X	DSI 9745-011	FIRE EXTINGUISHER RELOCATION KIT
1	1	D5420-1	DOUBLER PLATE
2	4	AN3-4A	HEX HEAD BOLT
3	8	MS20426AD3-5	CSK RIVET
4	4	MS21062L3	NUTPLATE

For customers with kits D350-567-013/-015/-017/-023/-025/117 @ CHG003 and later,
 Customers with kits D350-567-111 @ CHG007 and later,
 Customers with kits D350-567-115 @ CHG005 and later,
 Customers with kits D350-567-031/-031B/-111B/-115B @ CHG002 and later,
 Refer to Installation Instructions D350-567 and ICA-D350-567 and update the parts list as follows:

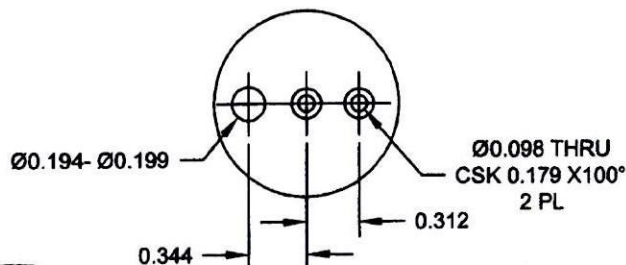
EDIT 5.0 ADD:

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
			1	1	D5420-1	DOUBLER PLATE
			4	4	AN3-4A	HEX HEAD BOLT
			8	8	MS20426AD3-5	CSK RIVET
			4	4	MS21062L3	NUTPLATE

EDIT 4.0/25.5 WEIGHT AND BALANCE:

*Note: Does not include fire extinguisher weight

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
DSI 9745-011 (Primary Location)	0.1 lb	+1.6 in	+16 in lb	72.2 in	7.2 in lb
Fire Extinguisher Relocation Kit	0.05 kg	+0.04 m	+0.02 m kg	1.83 m	0.1 m kg
DSI 9745-011 (Alternate location)	0.1 lb	-4.4 in	-44 in lb	65.4 in	6.5 in lb
Fire Extinguisher Relocation Kit	0.05 kg	-0.11 m	-0.01 m kg	1.66 m	0.1 m kg



DETAIL A

(NUT PLATE HOLE PATTERN)

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01

APPROVED
 BY: *[Signature]*
 D. SHEPHERD (DE # 02)

DATE: 16.04.06
 CERT. NO.: SH92-18
 ISSUE NO.: 6

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9745 SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	ALTERNATE FIRE EX LOCATION NTS
DATE	16.04.06	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

5.0 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
	9	12			2600-6	1/4 TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ. YD	2 SQ. YD	2 SQ. YD			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
				1	D3213-041	DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
			9	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
			9	8	AN960JD6	WASHER
			9	8	MS21042L06	NUT (OR MS21042-06)
			2	40	MS20470AD4-5	RIVET
			115	90	MS20470AD4-6	RIVET
			15	20	MS20470AD4-7	RIVET

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Description: REPLACEMENT INTERIOR FLOOR WINDOW

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